

GREEN

Date: Thursday, 4/26/2007 3:34:01 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 32079					
Estimate Number	: 10534					
P.O. Number	: N/A	S.O. No.	: N/A	Part Number	: D2574	
This Issue	: 4/26/2007	Type	: MACHINED PARTS	Drawing Number	: D2574 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: E	
Previous Run	: 31722			Material	: N/A	
Written By	:			Due Date	: 5/30/2007	
Checked & Approved By	:			Qty:	10	Um: Each
Comment	: Est Rev: As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: _____		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>832079</u> Double check by <u>J-F</u> .		

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

Engrd 07/06/03

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			

Engrd 07/06/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/06/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 32079

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 07/06/04 (10)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Fx

07/05/04

(10)

7.0 POWDER COATING POWDER COATING



m/04/176.

Comment: POWDER COATING

Powder Coat - OLIVE DRAB GREEN
(Ref: 4.3.5.1) as per QSI 005 4.3

Fx

07/06/04 (13)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



EJ 07/06/05 (2)

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

EJ 07/06/05 (4)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

R. Alodine

Job Completion



U. Alodine

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 QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32079
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date	
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440			
B	1.745	1.755		1.747	1.749	1.749	1.749			
C	3.495	3.505		3.499	3.499	3.499	3.500			
D	1.745	1.755		1.747	1.749	1.749	1.749			
E	7.990	8.010		8.000	8.000	8.001	8.001			
F	0.490	0.510		0.498	0.500	0.501	0.504			
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260			
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377			
I	0.490	0.510		0.495	0.503	0.502	0.502			
J	1.174	1.184		1.175	1.178	1.177	1.178			
K	0.558	0.578		0.564	0.570	0.570	0.570			
L	1.174	1.184		1.175	1.178	1.177	1.178			
M	1.365	1.375		1.366	1.369	1.368	1.369			
N	2.495	2.505		2.496	2.499	2.499	2.500			
O	4.119	4.129		4.124	4.121	4.121	4.120			
P	0.115	0.135		0.126	0.126	0.127	0.127			
Q	0.115	0.135		0.135	0.135	0.135	0.135			
R	0.240	0.260		0.251	0.251	0.251	0.251			
S	0.115	0.135		0.128	0.129	0.127	0.127			
T	0.178	0.198		0.188	0.188	0.188	0.188			
U	3.210	3.250		3.230	3.230	3.230	3.230			
V	0.230	0.250		0.240	0.240	0.246	0.241			
W	0.115	0.135		0.126	0.130	0.132	0.134			
X	0.307	0.312		0.311	0.311	0.311	0.311			
Y	0.760	0.765		0.765	0.765	0.765	0.765			
Z	0.352	0.372		0.364	0.358	0.364	0.364			
AA	0.470	0.530		0.500	0.500	0.500	0.500			
AB	0.615	0.635		0.616	0.639	0.627	0.628			
AC	0.053	0.073		0.063	0.063	0.063	0.063			
AD	0.240	0.260		0.246	0.248	0.253	0.253			
AE	1.500	1.520		1.510	1.512	1.512	1.510			
AF	0.115	0.135		0.135	0.135	0.135	0.135			
AG	0.240	0.280		0.240	0.265	0.269	0.262			
AH	0.240	0.260		0.250	0.247	0.248	0.249			
AI	2.000	2.020		2.000	2.000	2.000	2.000			
AJ	0.023	0.043		0.033	0.033	0.033	0.033			
Accept/Reject										

Measured by:	En/ ml	Audited by:	SA
Date:	07/06/01	Date:	07.06.02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32079
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

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B	1.745	1.755		1.746	1.748	1.747	1.748		
C	3.495	3.505		3.501	3.500	3.501	3.499		
D	1.745	1.755		1.746	1.748	1.747	1.748		
E	7.990	8.010		8.002	8.002	8.004	8.004		
F	0.490	0.510		0.501	0.499	0.498	0.500		
G	0.257	0.262	DT8683	0.259	0.259	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.504	0.503	0.502	0.501		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.571	0.572	0.567	0.565		
L	1.174	1.184		1.178	1.179	1.178	1.178		
M	1.365	1.375		1.368	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.497	2.499		
O	4.119	4.129		4.121	4.122	4.121	4.122		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
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S	0.115	0.135		0.128	0.127	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.241	0.239	0.236	0.240		
W	0.115	0.135		0.125	0.126	0.127	0.126		
X	0.307	0.312		0.311	0.311	0.312	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.623	0.623	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.246	0.245	0.245		
AE	1.500	1.520		1.511	1.511	1.512	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.265	0.265	0.266	0.266		
AH	0.240	0.260		0.249	0.246	0.244	0.245		
AI	2.000	2.020		2.000	2.001	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: *gml* / *SP*
Date: *07/06/02*

Audited by: *J.F.*
Date: *07/10/02*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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E	7.990	8.010		8.003	8.002				
F	0.490	0.510		0.502	0.499				
G	0.257	0.262	DT8683>	0.260	0.260				
H	0.375	0.380	DT8684	0.377	0.379				
I	0.490	0.510		0.499	0.497				
J	1.174	1.184		1.177	1.174				
K	0.558	0.578		0.565	0.566				
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AI	2.000	2.020		2.000	2.000				
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Accept/Reject									

Measured by: *en*
Date: *07/06/04*

Audited by: *J.F.*
Date: *07/06/04*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
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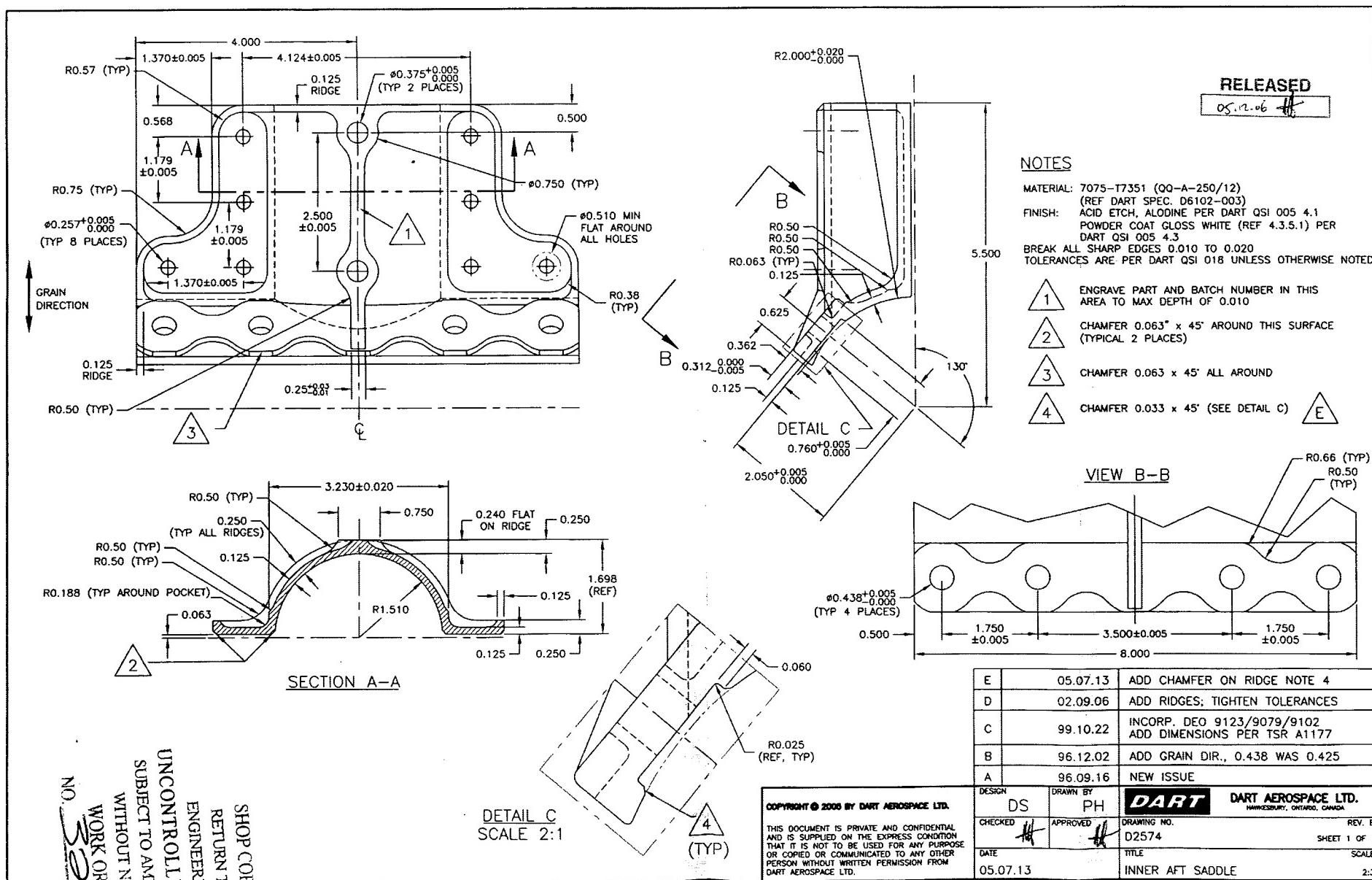
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



NO. 32019
 WORK ORDER
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 ENGINEERING
 RETURN TO
 SHOP COPY
 UNCONTROLLED COPY

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